


Date: Tuesday, 7/17/2007 1:59:32 PM  
 User: Kim Johnston

## Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 33580	
Estimate Number : 12577	
P.O. Number : N/A	Part Number : D3562042
This Issue : 7/17/2007 S.O. No. : N/A	Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : AC
Previous Run : 32721	Material : N/A
Written By : 	Due Date : 8/3/2007
Checked & Approved By : _____	Qty: 5 Um: 8 Each
Comment : Est Rev:A New Issue 06-11-09 JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B32858

Check Material for any Dents or Defects

a.m. 07.07.24

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B33841

a.m. 07.07.24

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

a.m. 07.07.24

2-Deburr and bevel ends for welding

a.m. 07.07.24

3-Weld (1)end cap as per Dwg D3562&amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod \_\_\_\_\_

4-Grind end cap welds flush as per Dwg D3562

to be Done  
 Step #13

THE UNIVERSITY OF CHICAGO

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC5



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D3560042



ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT 3 34965

9.0

D3560044



ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

Batch: 3 34967

10.0

MS20600AD4W5



Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 216.0000 Each(s)

Blind Rivet

batch: 1105125

11.0

SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. Touch up alodine.

Rivet legs using Magnabond as per dwg D3562.





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: 3104677

Q.M. 07-10-04 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



check in Helicopter



Comment: INSPECT WORK TO CURRENT STEP

07-10-04 (3)  
07-10-09 (45-042)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod 1103794

07-10-09 (5)

2-Grind end cap welds flush as per Dwg D3562

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Q.M. 07-10-10

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-10-10

16.0

POWDER COATING

POWDER COATING



M 105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.F. 07/10/11

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M 105684

FL 07/10/11 (5)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.5 \* SEE W/D CHG 17 D2808-1 spacer B 32752

18.6 QC#5 inspect work to current step

M.F. 07-10-12





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

SB 27 11/10/12

20.0

QC21

FINAL INSPECTION/W/O RELEASE



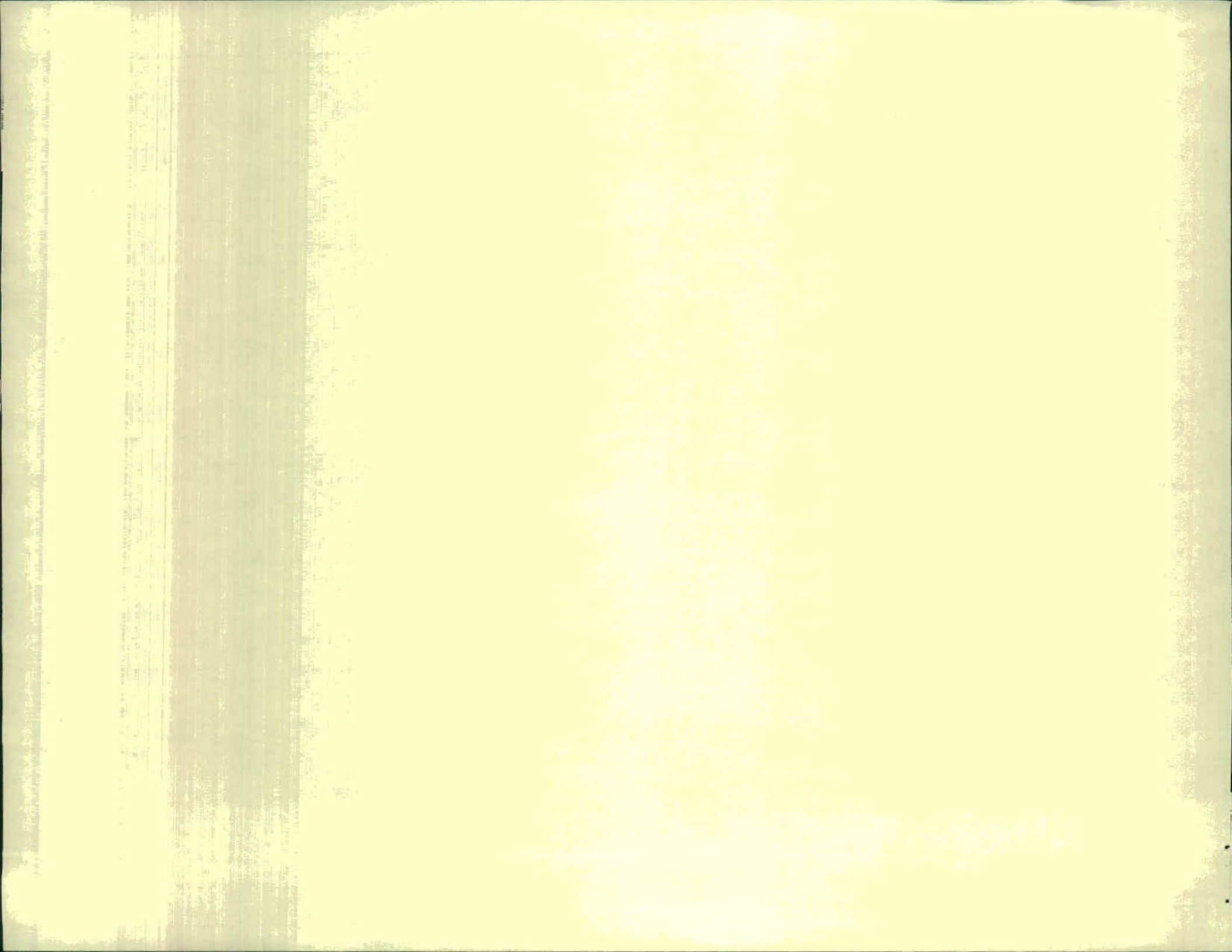
Comment: FINAL INSPECTION/W/O RELEASE

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D 07/10/12

Job Completion



h 07-10-12

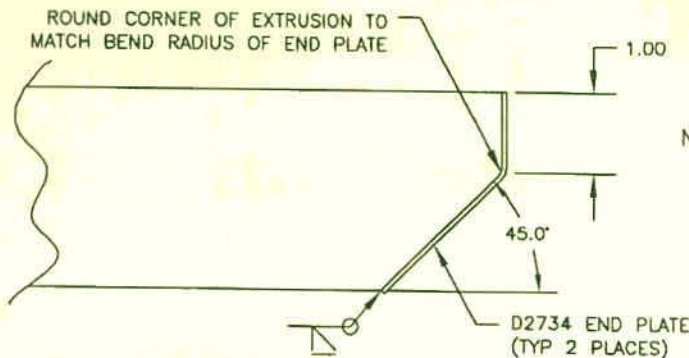




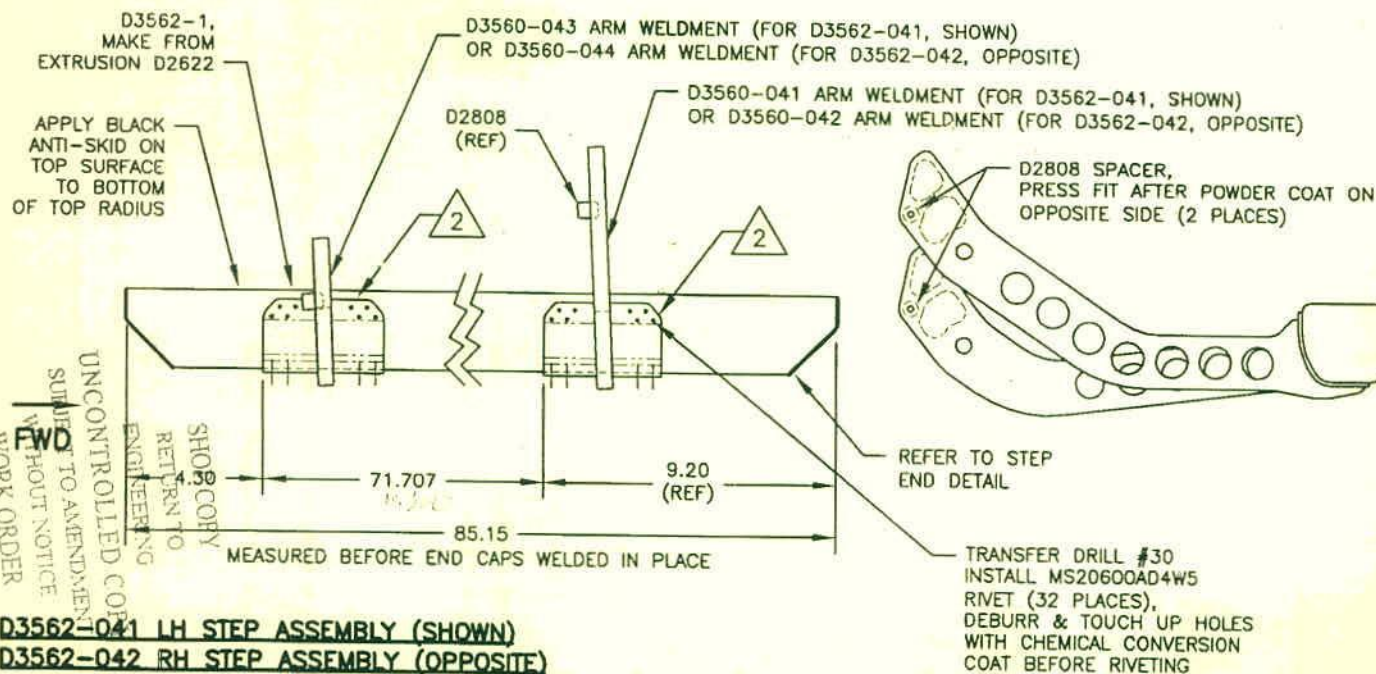
**DART****RELEASED**  
07.06.19

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>GP</i>	APPROVED <i>GP</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
07.06.19	D3562	SHEET 1 OF 1
	TITLE	SCALE
	STEP ASSEMBLY	NTS
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTs

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**TYPICAL STEP END DETAIL**  
NOT TO SCALE



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

